

Work Order ID 59157

Thursday, May 27, 2010 9:22:53 AM



Page 1

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10-5-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☐ Dwg Rev: *D* ☐ Prog Rev: *D* ☐ 2-
Deburr if necessary

304. 062

MAT NOT PULLED

B10-5-28

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-5-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/05/31

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, May 27, 2010 9:22:53 AM



Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

0.00

Brake NC

NC BRAKE

Memo

0.00

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00 AM □ OVEN TEMPERATURE: 320°F
 10:30 AM □ FINISH TIME: 320°F

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Page 3

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Item Name: Wearshoe

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	BR	10-6-1	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-19</u> Memo	0.00 0.00				12	BR	10-6-1	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						10/06/01	

10-6-01
12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, May 27, 2010 9:22:57 AM

Page 1

Work Order ID: 59157



Parent Item: D3564-5



Parent Item Name: Wearshoe

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Start Qty: 12.00

Required Qty: 12.00

M304S16GA

Purchased

No

100

sf

6.7443

1.5

18.94737



304/316 Sheet .063

810-5-28

Location

Loc Qty

Loc Code

MAT

6.74427

111323

0

114467

6.74427

114467

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59157
Description: Wearshoe		Part Number:	D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓			
6.75	+/-0.030	6.75	✓			
10.00	+/-0.030	10.00	✓			
20.00	+/-0.030	20.00	✓			
30.00	+/-0.030	30.00	✓			
2.50	+/-0.030	2.50	✓			
3.227	+/-0.010	3.227	✓			
38.500	+/-0.010	38.500	✓			
5.500	+/-0.010	5.500	✓			
2.50	+/-0.030	2.50	✓			
2.432	+/-0.010	2.434	✓			
0.300 x 0.300	+/-0.010	307X309	✓			
Ø0.188	+0.005/-0.001	.191	✓			
R0.375	+/-0.010	.375	✓			
0.063	+/-0.010	.060	✓			

Measured by:	JB
Date:	10-5-28

Audited by:	S
Date:	10/05/31

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

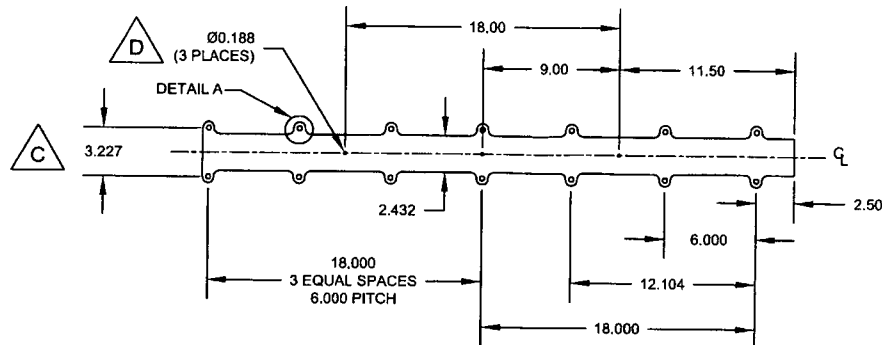
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

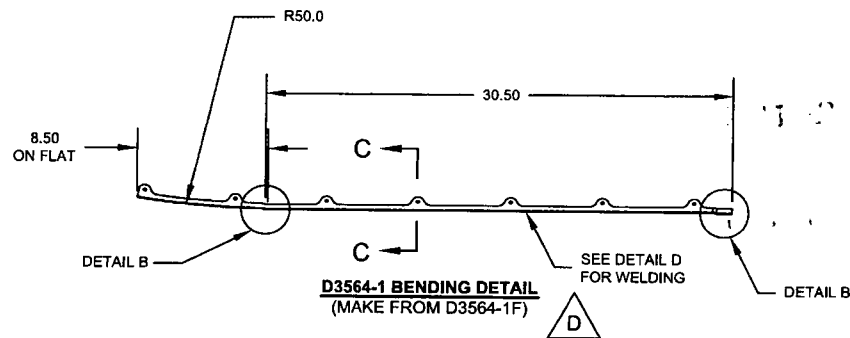
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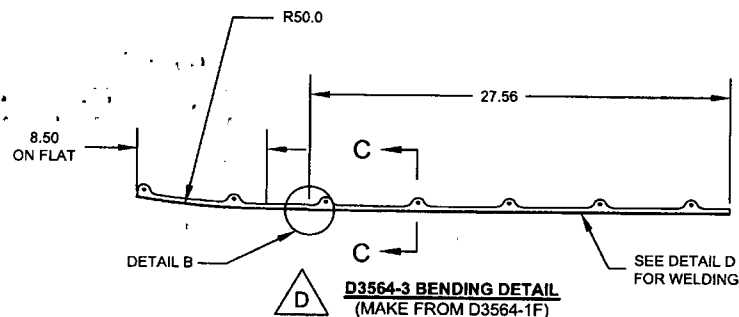
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEXT (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59157
B810-5-27

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH	DRAWING NO.	REV. D
DE APPR.	PH	D3564	SHEET 1 OF 3
DATE	07.08.21	TITLE	SCALE
		WEARSHOE	1:8
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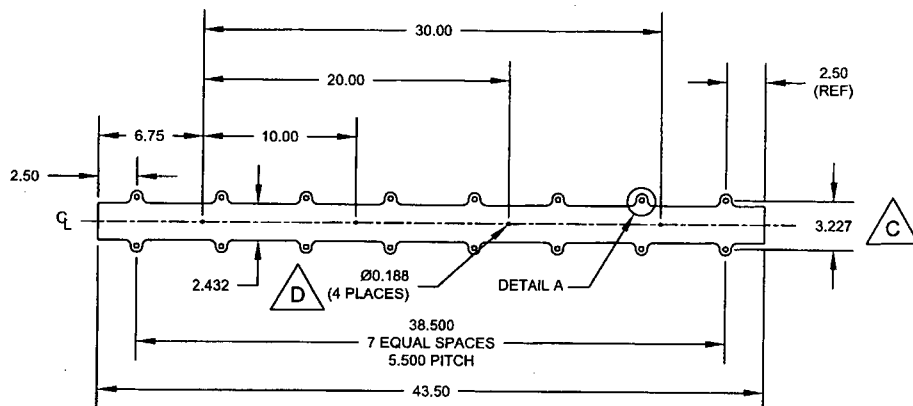
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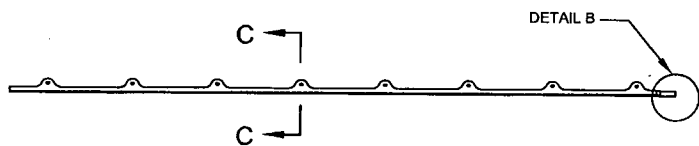
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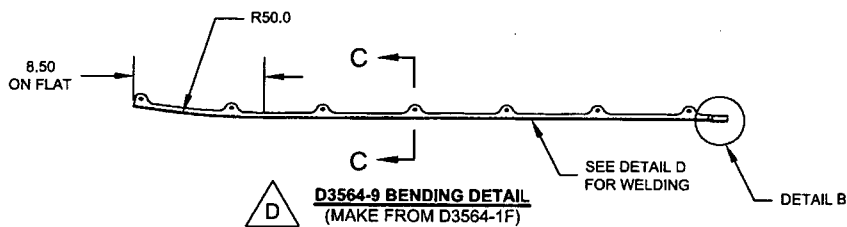
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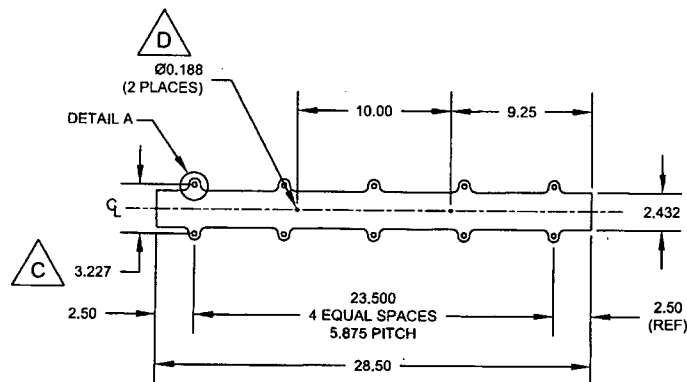
D3564-5F FLAT PATTERN



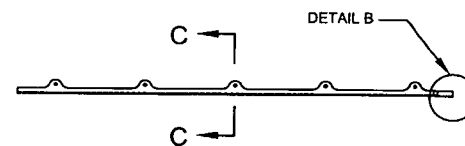
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



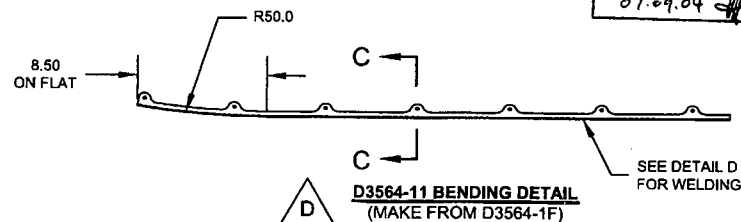
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

W659157

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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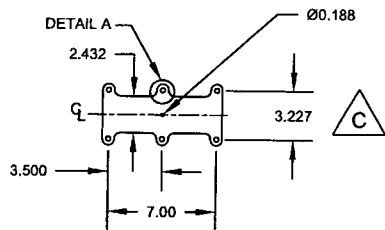
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

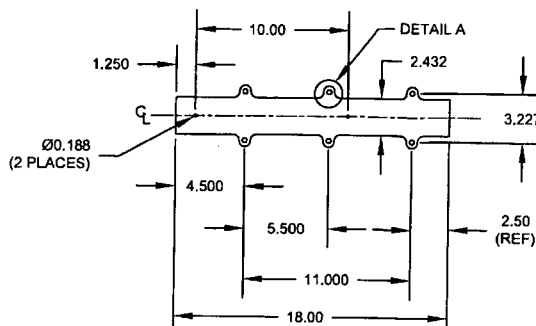
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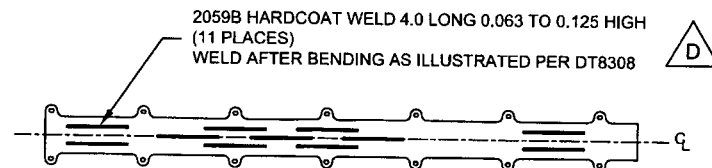
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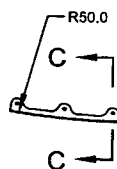
D3564-13F FLAT PATTERN



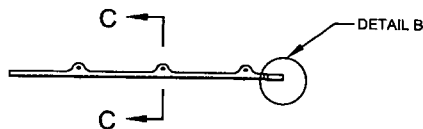
D3564-15F FLAT PATTERN



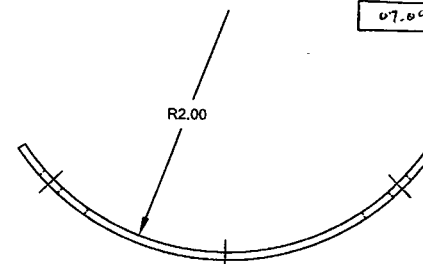
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



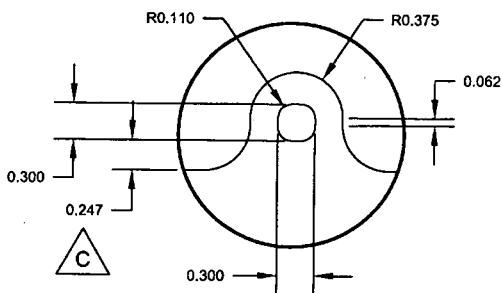
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



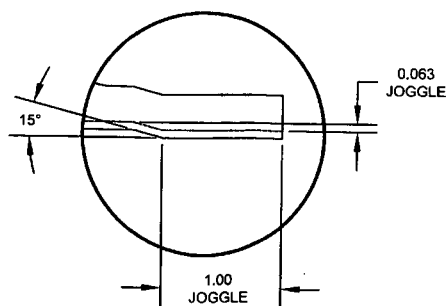
SECTION C-C
SCALE 1:1

RELEASED

07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
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w/0 59157

8 7 6 5 4 3 2 1

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